Work Order ID 72357

Friday, July 22, 2011 2:51:47 PM

Item ID: D2724-042 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: 206L Step Assembly

Start Date: 7/22/2011 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 7/29/2011 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** K **Date:** 11-07-22 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2724	Rev C								
100	Large Fab	0.00							
Large Fab		0.00							
Large Fab	**Memo**								
	Cut D2724-2 using D2622 extrusion as per Dwg D2724 Deburr and bevel ends for welding								
110	Large Fab	0.00							
Large Fab		0.00							
Large Fab	**Memo**								
	Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898 followed by Jig A/R AL ROD Batch: 114514 117884 Grind end cap welds flush								

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11.08.23 2 ø

te 11.08.25.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 72357

Friday, July 22, 2011 2:51:48 PM

Item ID: D2724-042 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: 206L Step Assembly

Start Date: 7/22/2011 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 7/29/2011 **Req'd Qty:** 2.00 **Customer:**

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Run Start

Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00				2	Ø	BE 11/08/26	
QC	**Memo**	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00				2			
QC	**Memo**	0.00				RM			
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				(2)	Ø		
HandFinish	**Memo**	0.00							
Hand Finishing									

11.09.06

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 72357

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				2	ϕ		
QC	**Memo**	0.00 SB 11/09/07							
Quality Control									
160		0.00				2	ϕ		
Large Fab	Large Fab								
Large Fab	**Memo**	0.00							
	Inspect for foreign object per QSI 024								
	Weld Remainig end cap as per Dwg D2724 A/R AL ROD Batch: M1145K								
	Grind end plate flush.								
170	QC10- Inspect visual per QSI004- ground welds	0.00				x2 RM			
QC	**Memo**	0.00 SJ 11/07/13							
Quality Control									

AK 11.09.07
AE 11.09.12

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 72357

Friday, July 22, 2011 2:51:48 PM

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Start Date: 7/22/2011 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 7/29/2011 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00				KD RH			
QC	**Memo**	0.00							
Quality Control									
190	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 10:10 OVEN TEMPERATURE: 320°F FINISH TIME: 10:40								

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2x Ø M-L 11/04/13

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 72357

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC3- Inspect Part Finish	0.00				2	BR	11-9-13	
QC	**Memo**	0.00							
Quality Control									
220	Wing Walk as per dwg QSI005 4.4 Batch M18813	0.00							
HandFinish	**Memo**	0.00				2	BR	11-9-13	
Hand Finishing									
230	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00				ZRH		11/08/13	
Quality Control									

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W/O:		WORK ORDER CHANGES					
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Work Order ID 72357

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Start Date: 7/22/2011 **Start Qty:** 2.00 **Cust Item ID:**

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Identify as per dwg & Stock Location:_____	0.00					10/4/14	2	
Packaging	**Memo** PPP 72365	0.00							
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00					11/9/14		
QC	**Memo**	0.00							
Quality Control									

MF
11-09-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Friday, July 22, 2011 2:51:56 PM

Work Order ID: 72357

Parent Item: D2724-042

Parent Item Name: 206L Step Assembly

Start Date: 7/22/2011 **Required Date:** 7/29/2011

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2734 Step End Plate		Manufactured	No			110	Each	59.0000	1	2		11.09.09	
				Location		**Loc Qty**		**Loc Code**					
				WA		59							
				70701		59				2			
D3458-1 Step Mounting Plate		Manufactured	No			110	Each	9.0000	2	4		11.08.23	
				Location		**Loc Qty**		**Loc Code**					
				WA018 B71593		9							
				63075		9				4			
D3458-3 Step Mounting Plate		Manufactured	No			110	Each	16.0000	2	4		11.08.23	
				Location		**Loc Qty**		**Loc Code**					
				WA018		16							
				63076		16				4			
D2734 Step End Plate		Manufactured	No			160	Each	59.0000	1	2		11.09.09	
				Location		**Loc Qty**		**Loc Code**					
				WA		59							
				70701		59				2			

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Friday, July 22, 2011 2:51:56 PM

Work Order ID: 72357

Parent Item: D2724-042

Parent Item Name: 206L Step Assembly

Start Date: 7/22/2011 **Required Date:** 7/29/2011

Start Qty: 2.00 **Required Qty:** 2.00

D2622-120C	Manufactured	No		100	Each	117.7000	1	2

Step Extrusion

Ae 11.08.23

Location	Loc Qty	Loc Code
HALL	108	
64409	6	
68293	102	
WA	9.7	
46910	2	
66970	7.7	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

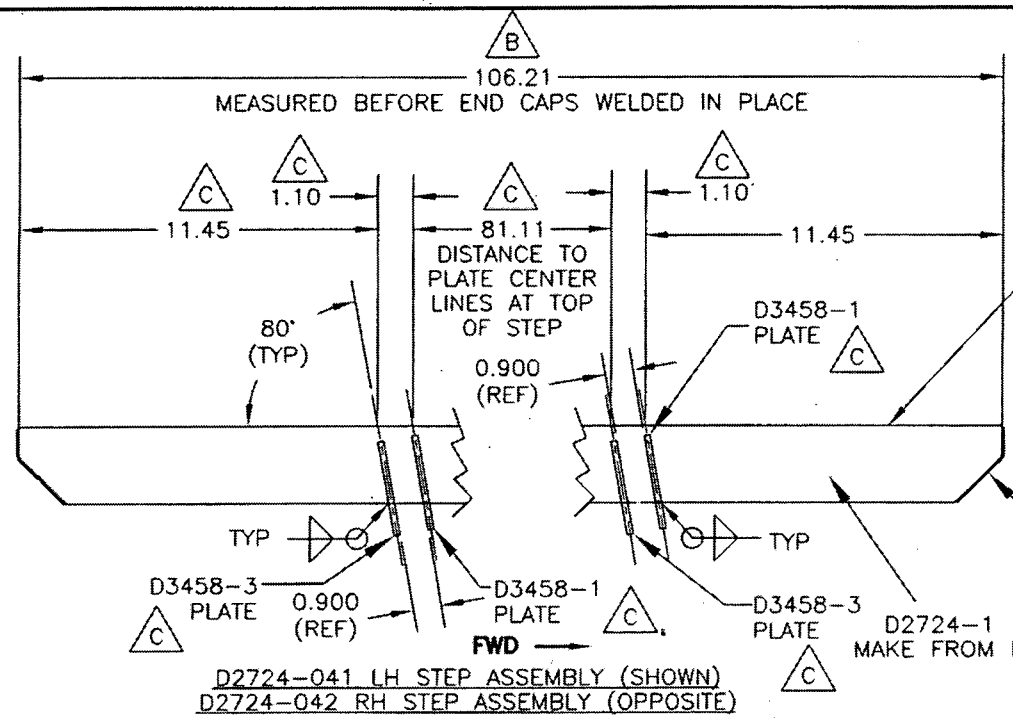
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

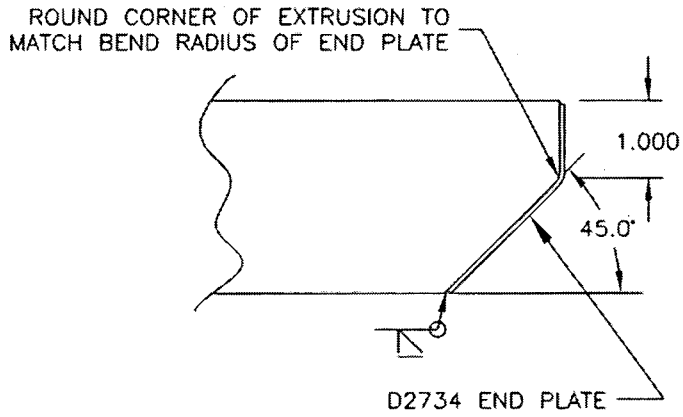
NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

RELEASED 05.11.14

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 72357
11-07-22

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2724-041/-042 STEP ASSEMBLY

1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

C	05.09.19	RE-DESIGN, ADD D3458-1/-3	
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
A	97.12.04	NEW ISSUE	

DESIGN: KE | DRAWN BY: PH | CHECKED | APPROVED | DATE: 05.09.19

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

TITLE: 206L/407 STEP ASSEMBLY
DRAWING NO. D2724
REV. C
SCALE: NTS
SHEET 1 OF 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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